

FIG. 2

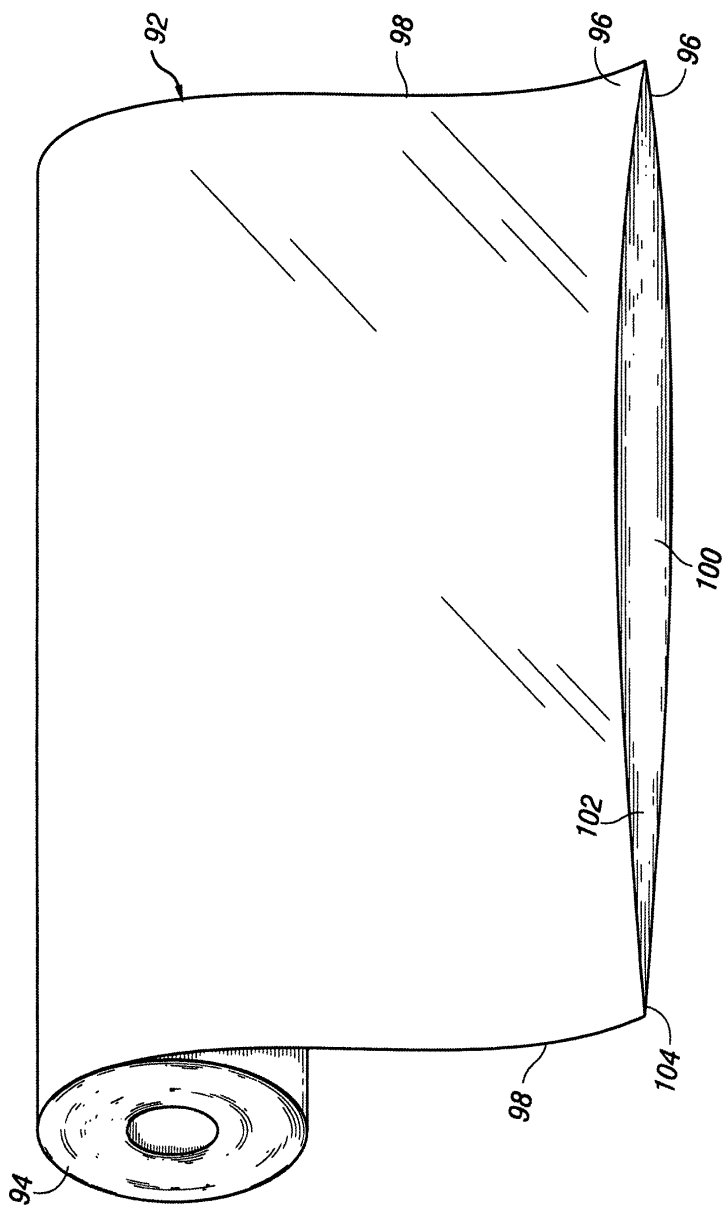


FIG. 3

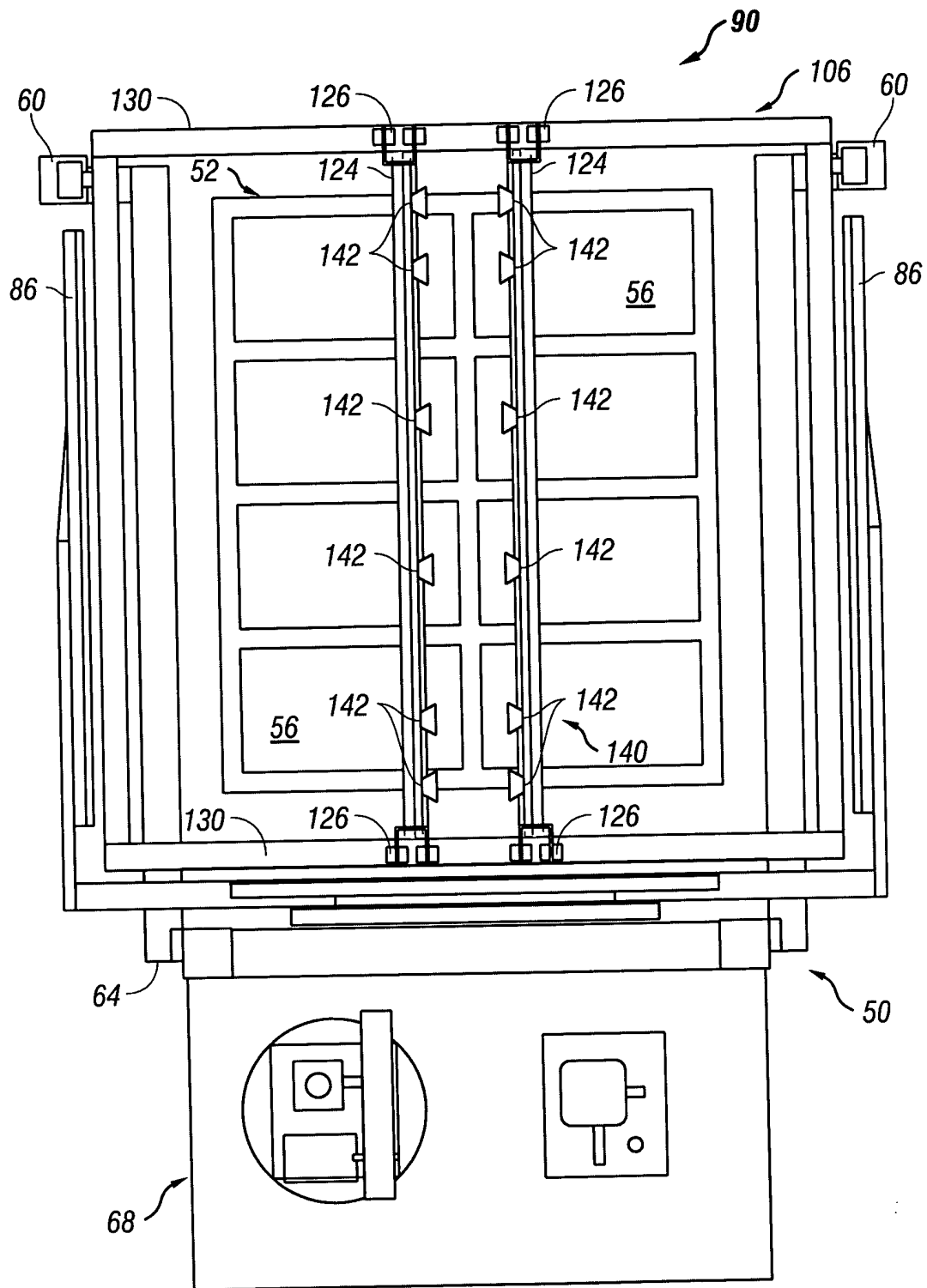


FIG. 4

5/23

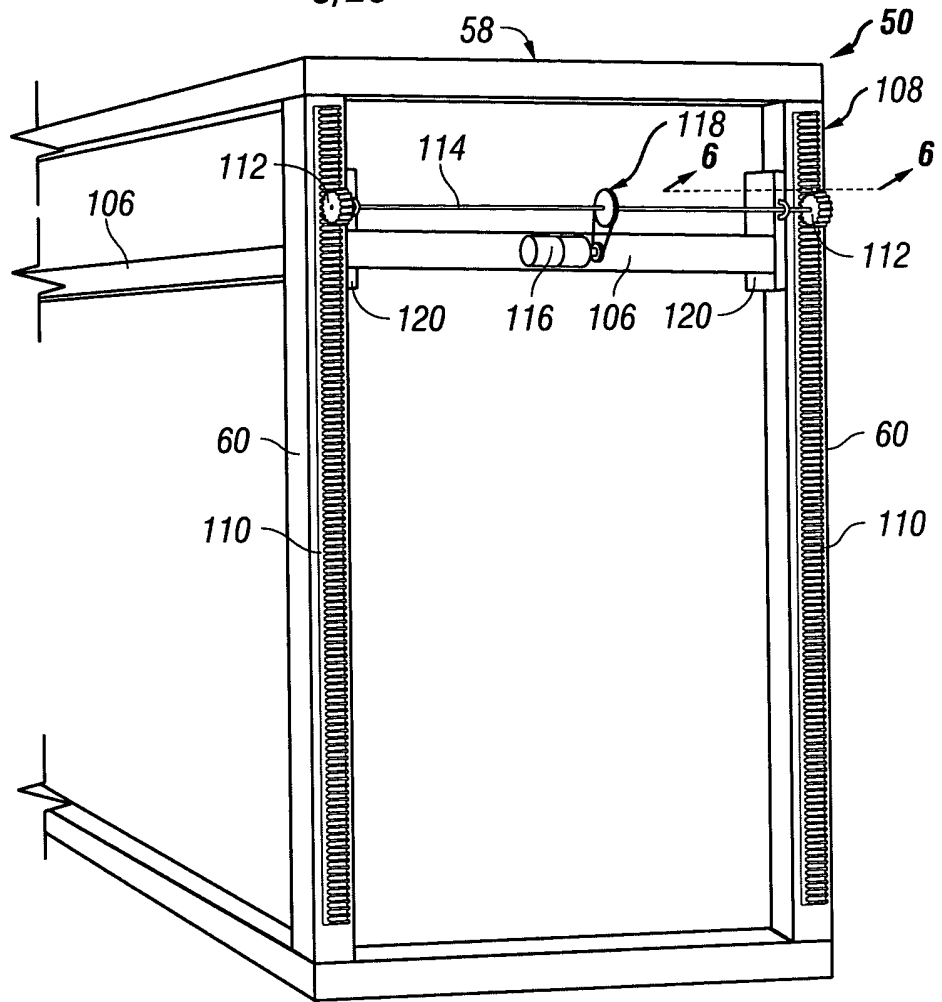


FIG. 5

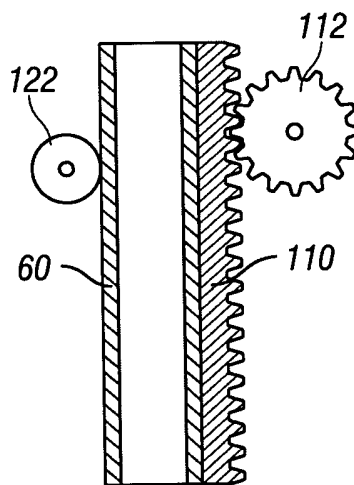
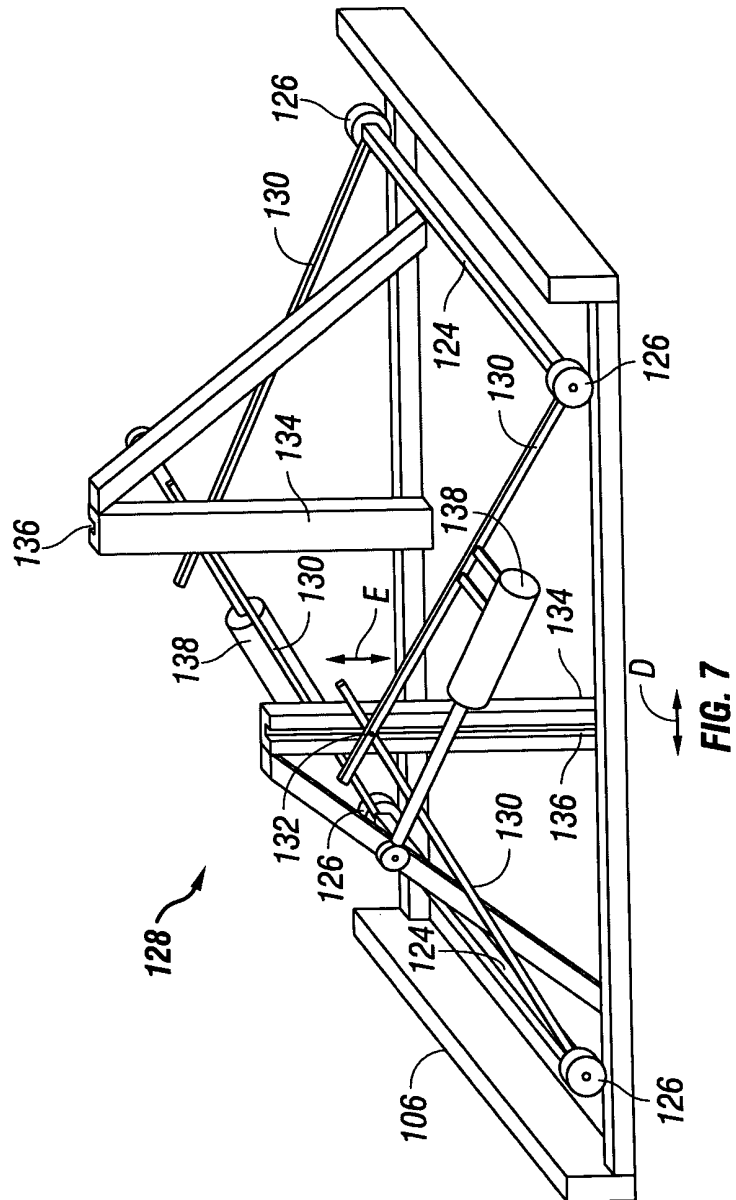
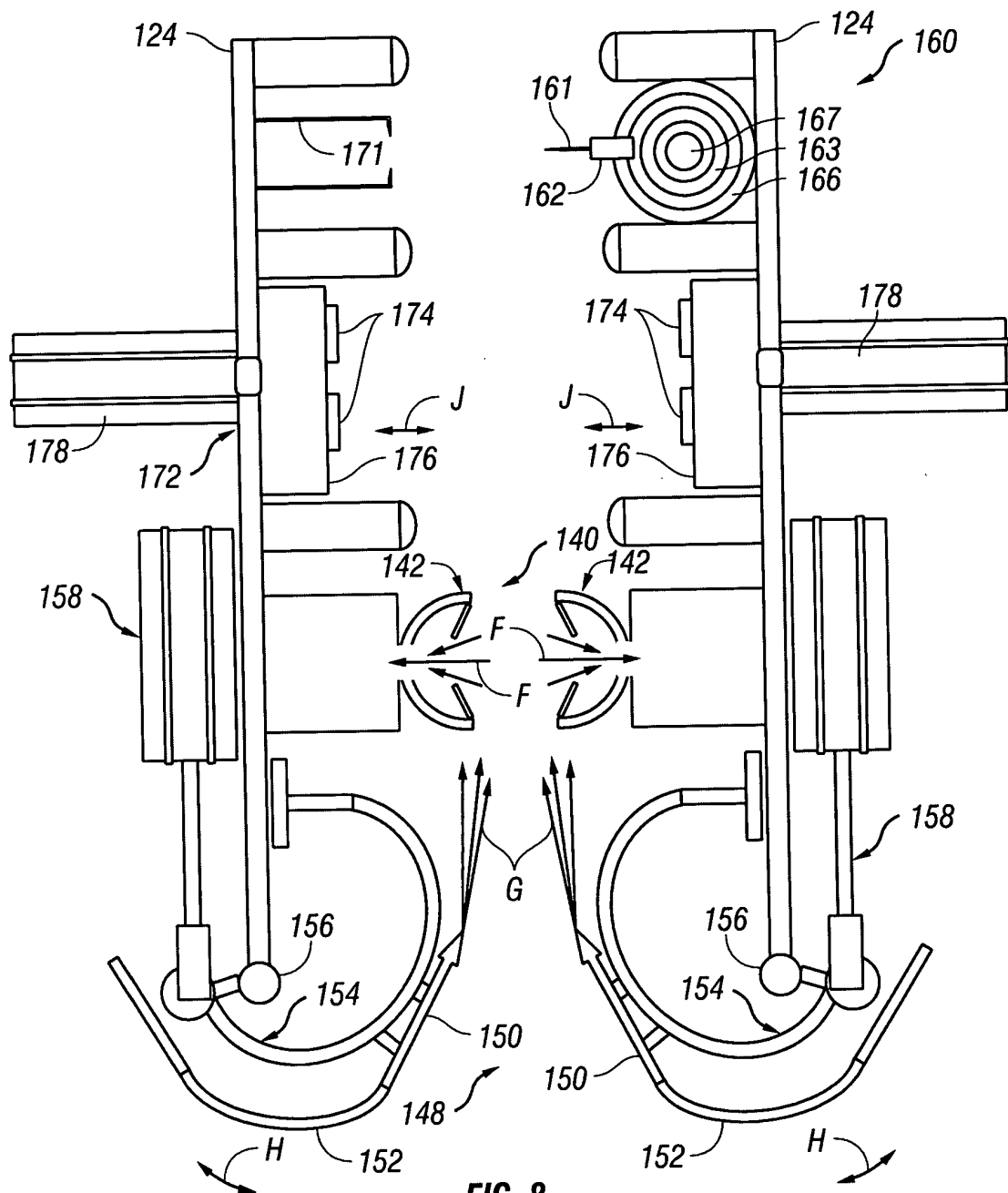


FIG. 6





8/23

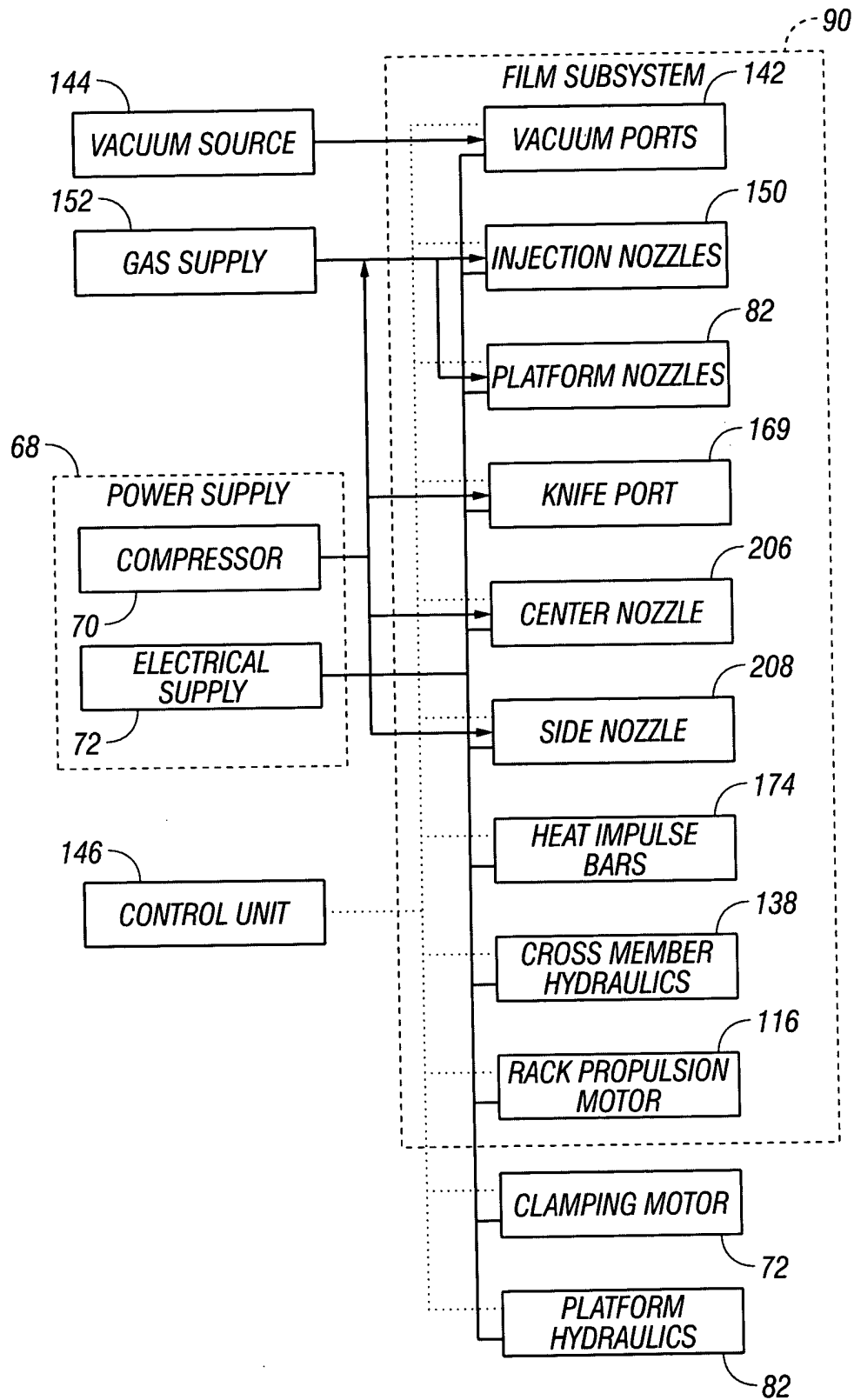


FIG. 9

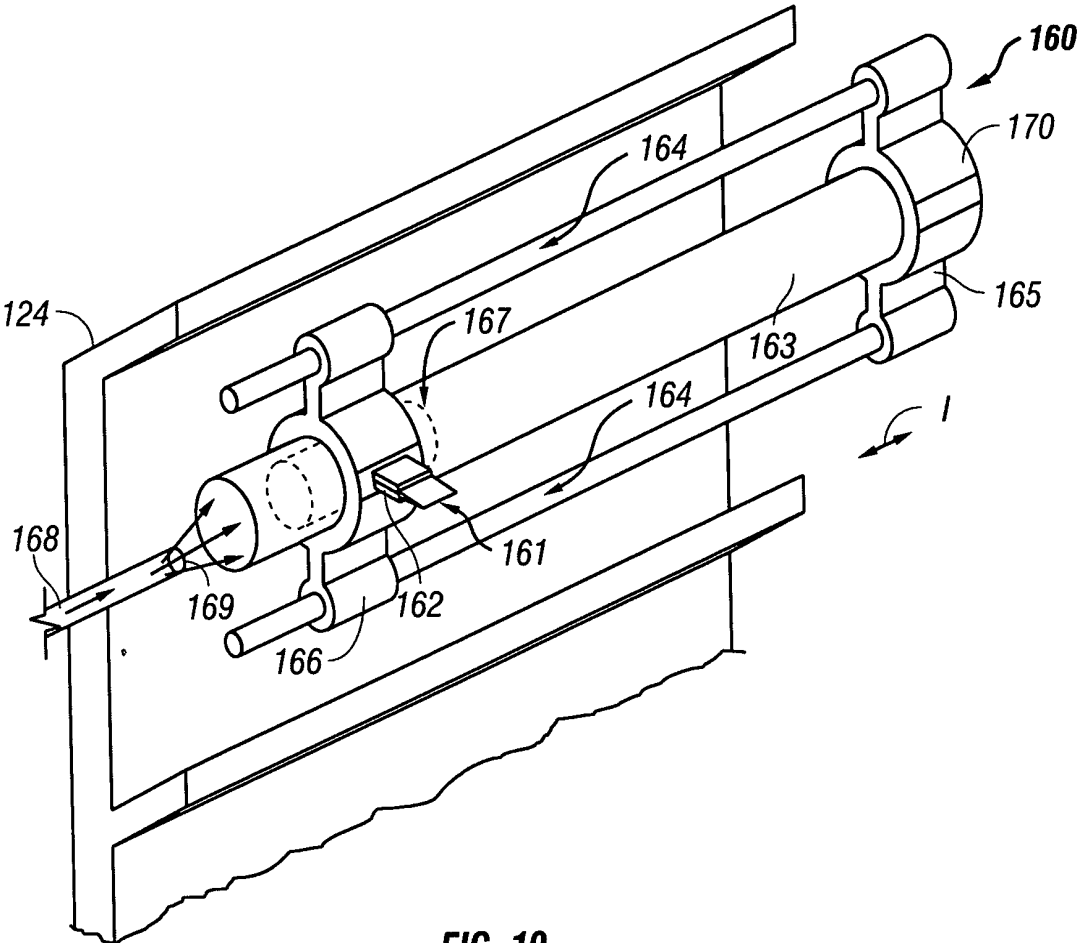


FIG. 10

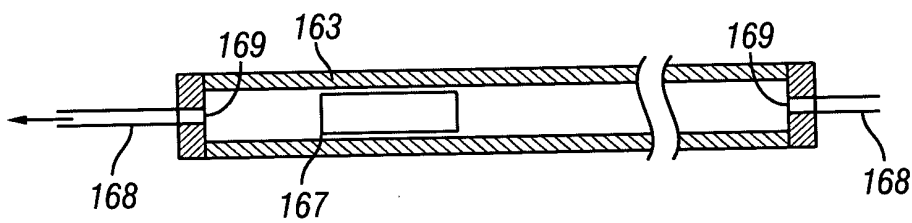


FIG. 11

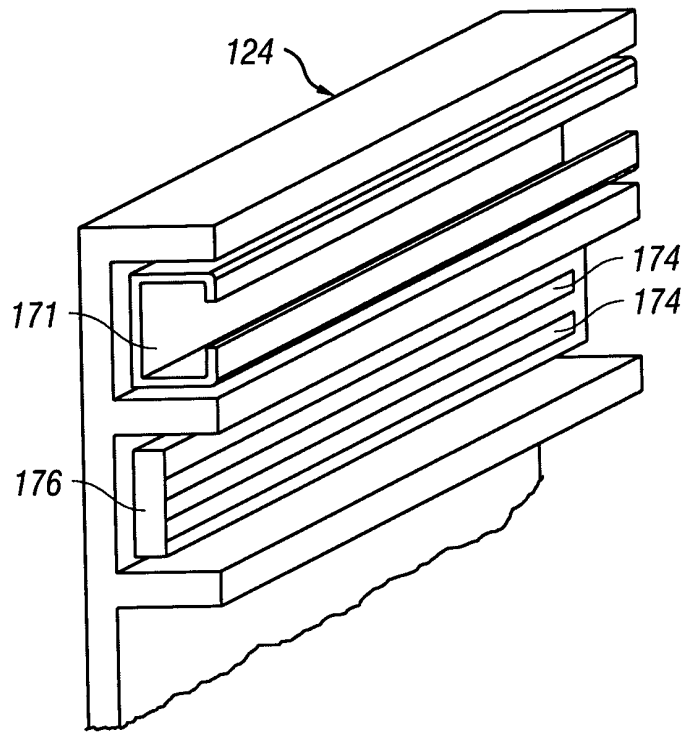


FIG. 12

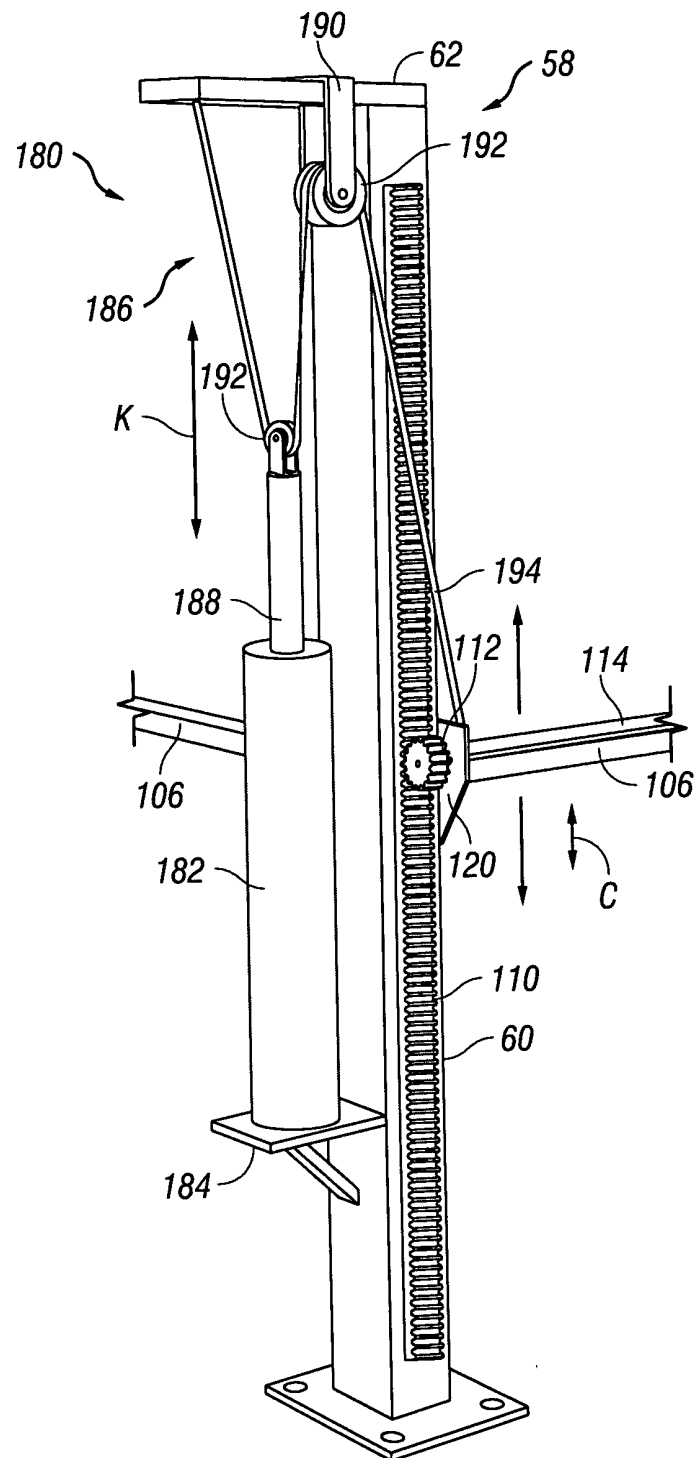


FIG. 13

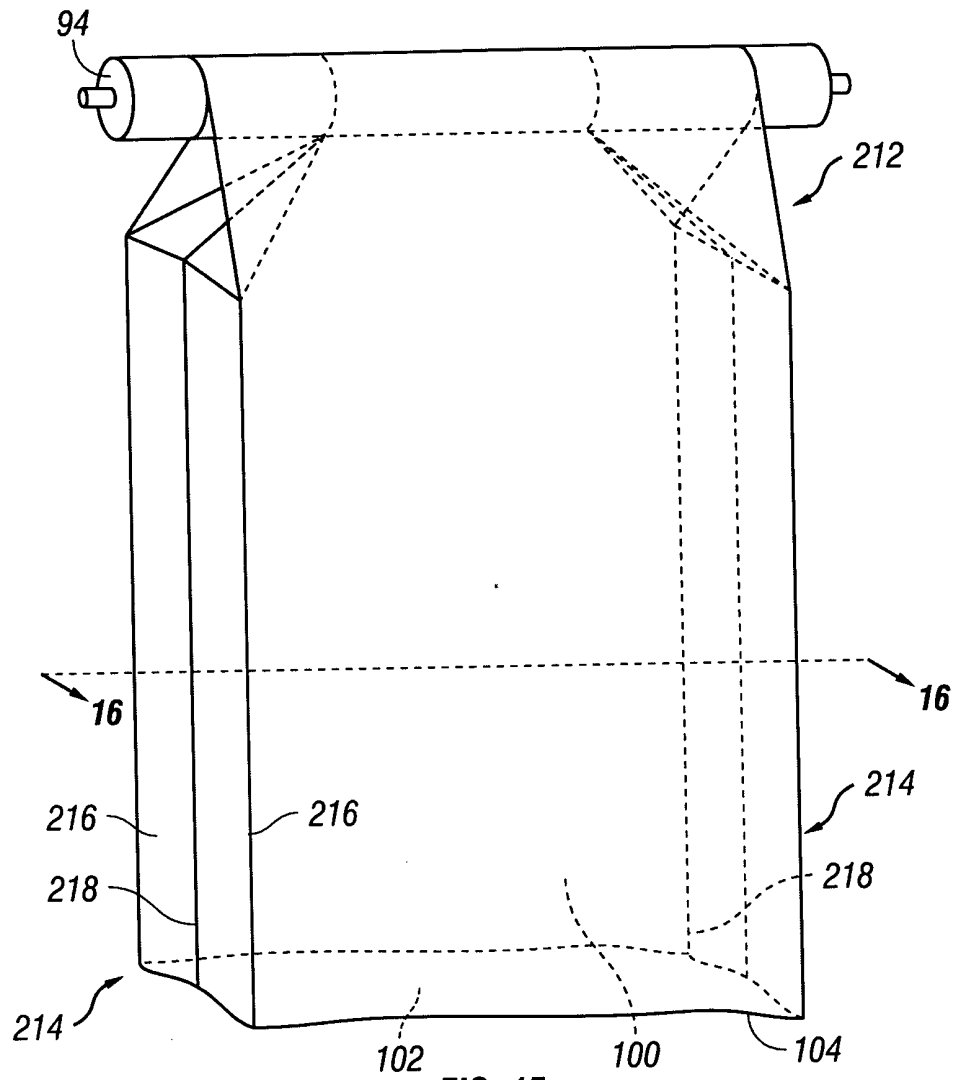


FIG. 15

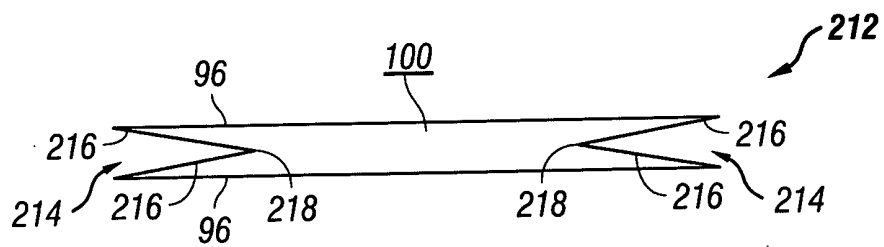


FIG. 16

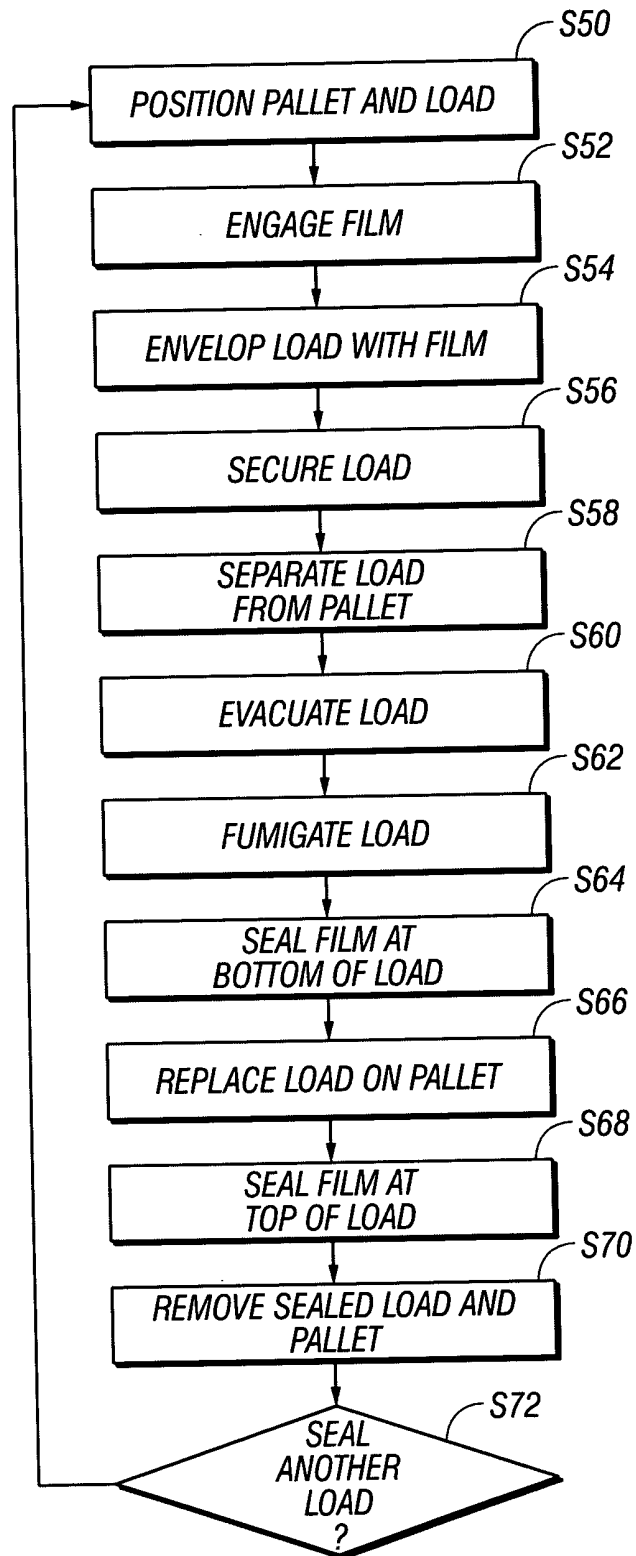


FIG. 17

FILM RACK POSITIONS:		DISTANCE
X	START POSITION	0
Y	LOW POSITION	-10
Z	INTERMEDIATE POSITION	-2

STEP	FUNCTION	TIME (sec)	EXTRA TIME	FILM SUBSYSTEM									
				VACUUM SYSTEM	INJECTION NOZZLES		HEAT SEAL BAR	CUT-OFF KNIFE	SIDE AIR NOZZLE	CENTER AIR NOZZLE			
					POSITION	AIR					VACUUM	GAS	
1	CROSS MEMBERS CLOSE	t=0	DURING	ON									
2	CROSS MEMBERS OPEN	3	DURING	ON	IN	ON							
3	RACK DOWN TO Y	6	DURING	ON	IN	ON							
4	CLAMP CLOSES	2	DURING	OFF	IN	OFF							
5	PLATFORM DOWN	3	DURING		IN					ON			
6	CROSS MEMBERS CLOSE	3	20		IN	ON							
6.1						OFF							
6.2	INJECT GAS (IF DESIRED)						ON						
6.3							OFF						
6.4					OUT								
6.5	SEAL FILM							ACTIVE		OFF			
6.6											ON		
7	CROSS MEMBERS OPEN	3	DURING								ON/OFF		
8	PLATFORM UP	3	DURING										
9	CLAMP OPENS	1											
10	RACK UP TO Z	5											
11	CROSS MEMBERS CLOSE	3	7							ON			
11.1	CUT/SEAL FILM AT TOP							ACTIVE	ACTIVE	OFF			
11.2													
12	CROSS MEMBERS OPEN	3											
13	RACK UP TO X	2											
14	RETURN TO STEP 1	3											

FIG. 18

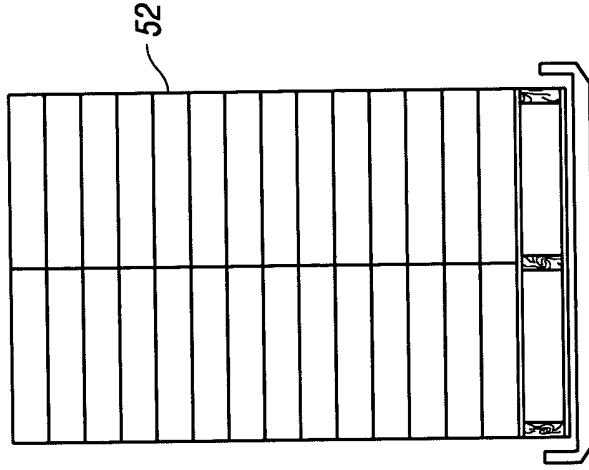
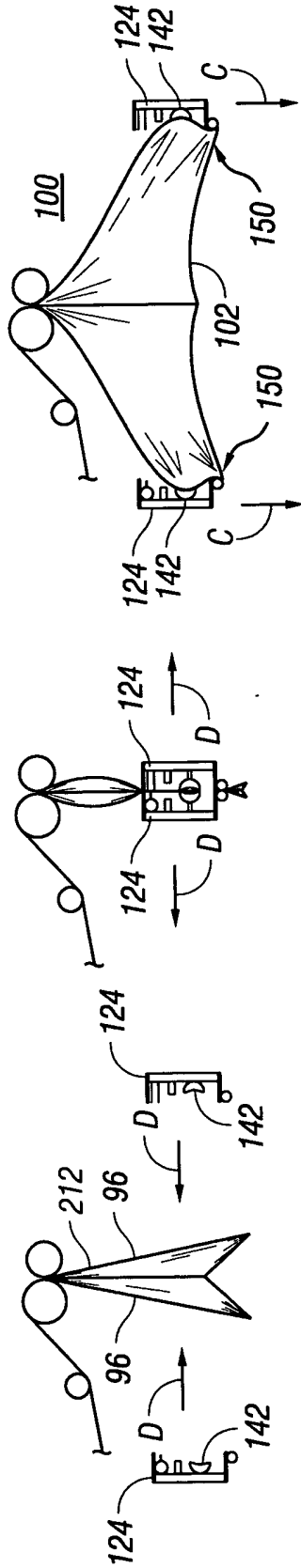


FIG. 19C

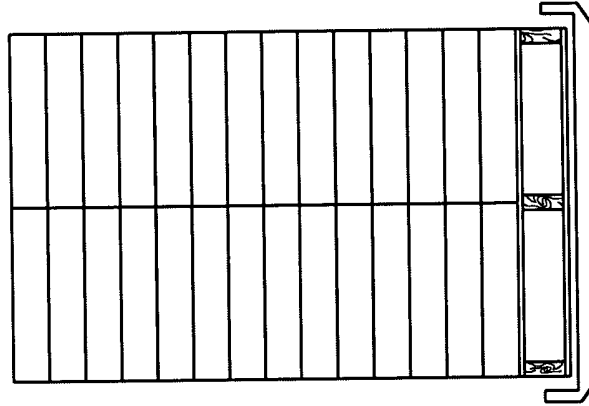


FIG. 19B

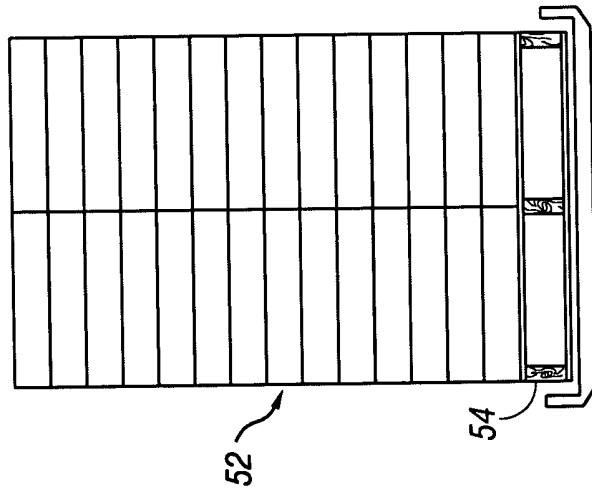
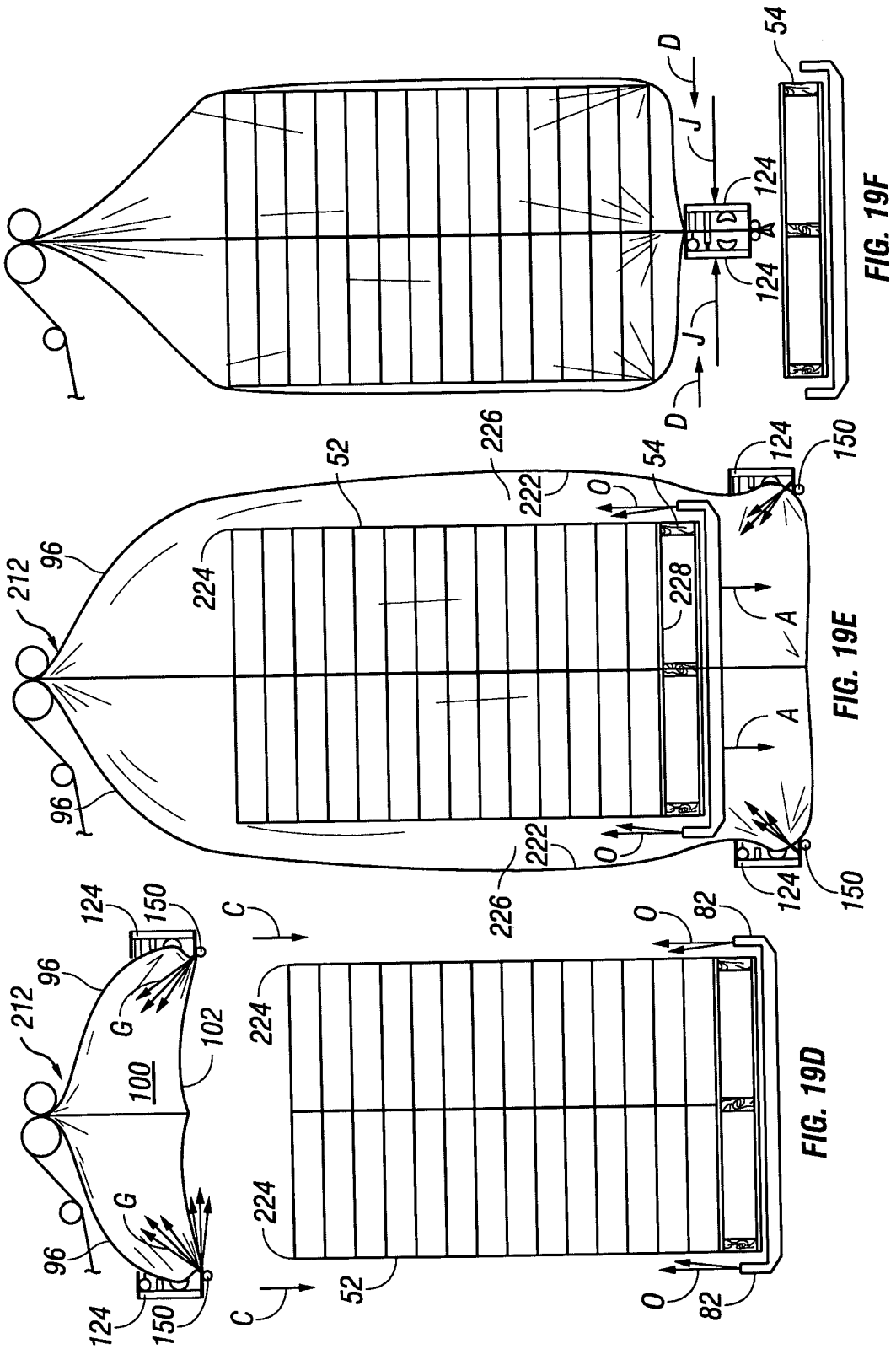


FIG. 19A



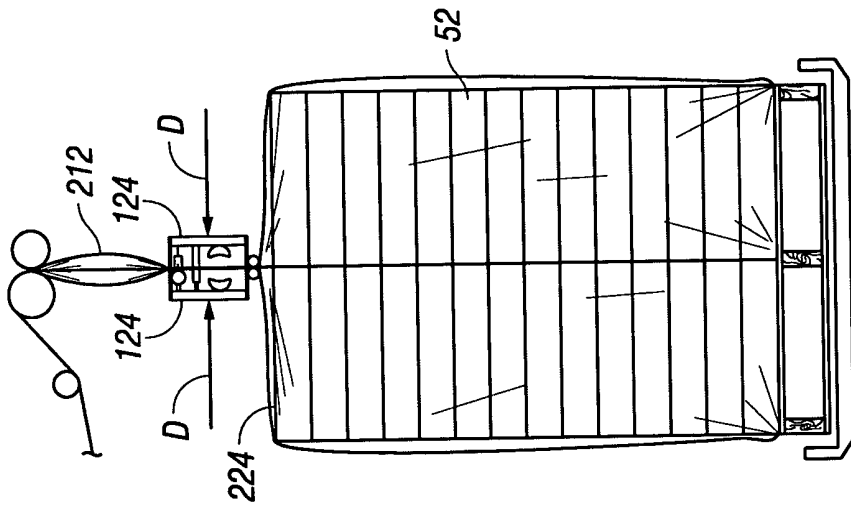


FIG. 19I

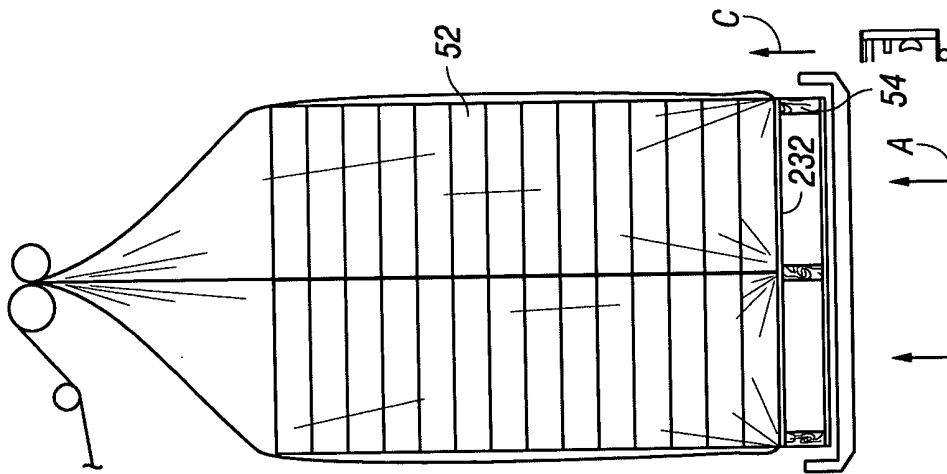


FIG. 19H

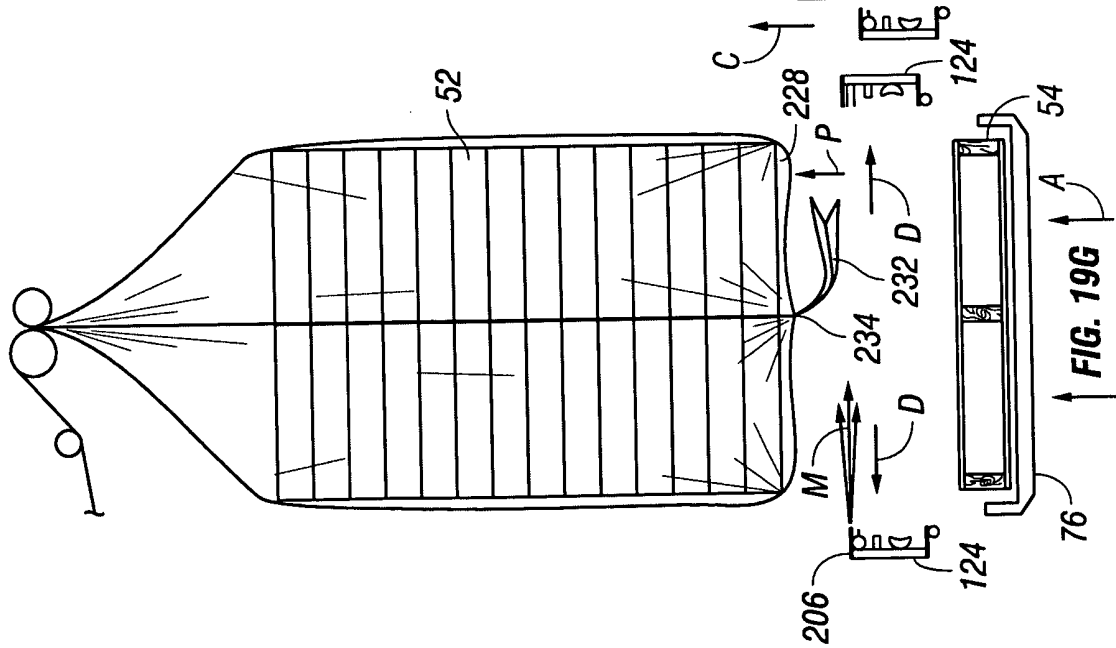


FIG. 19G

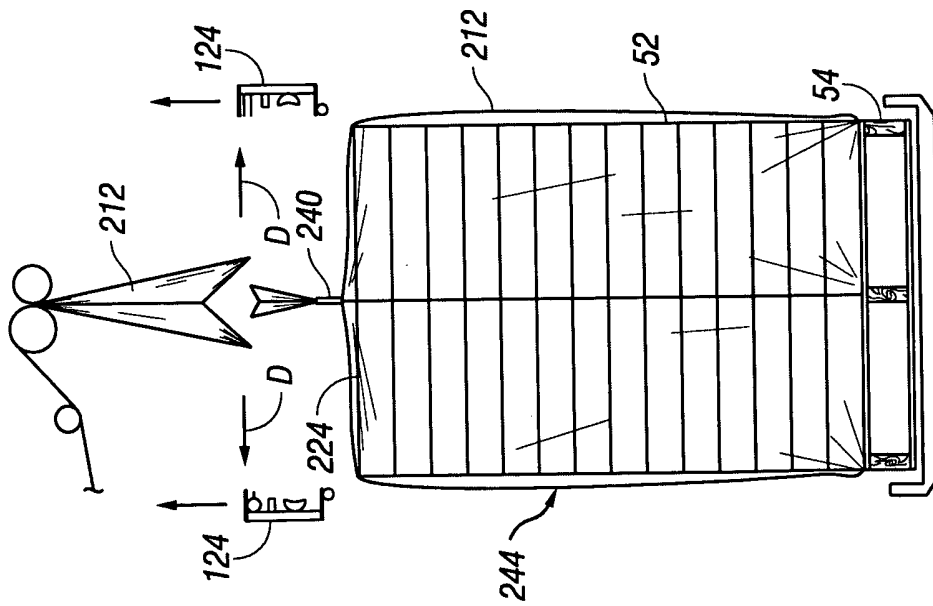


FIG. 19J

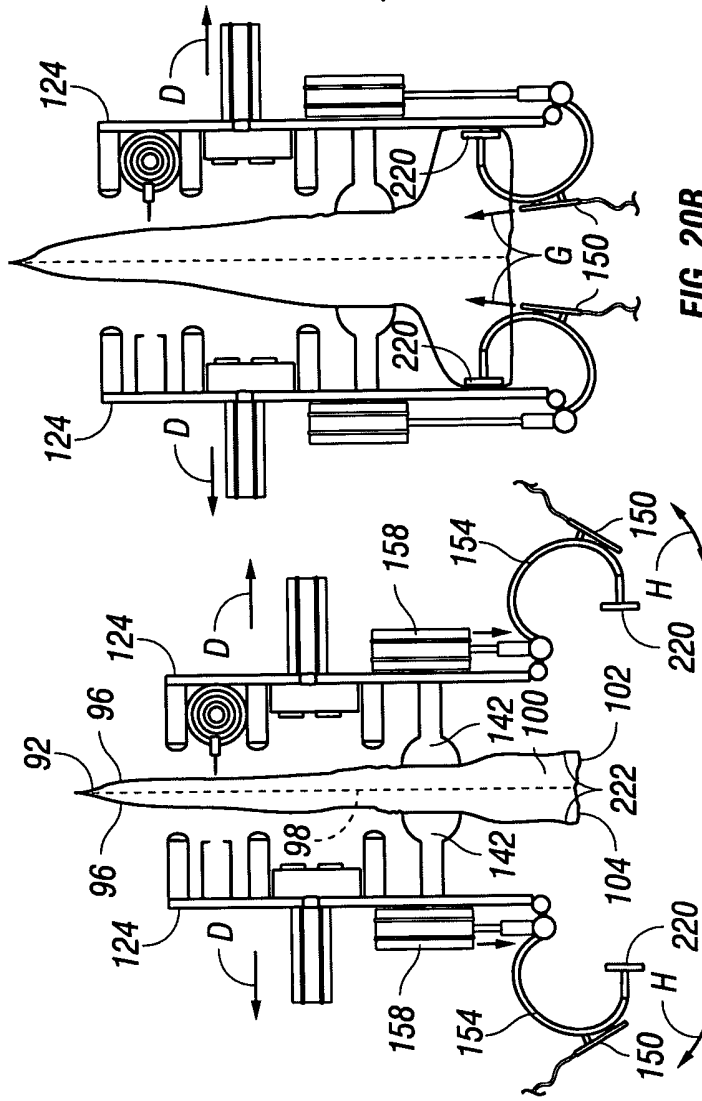


FIG. 20B

FIG. 20A

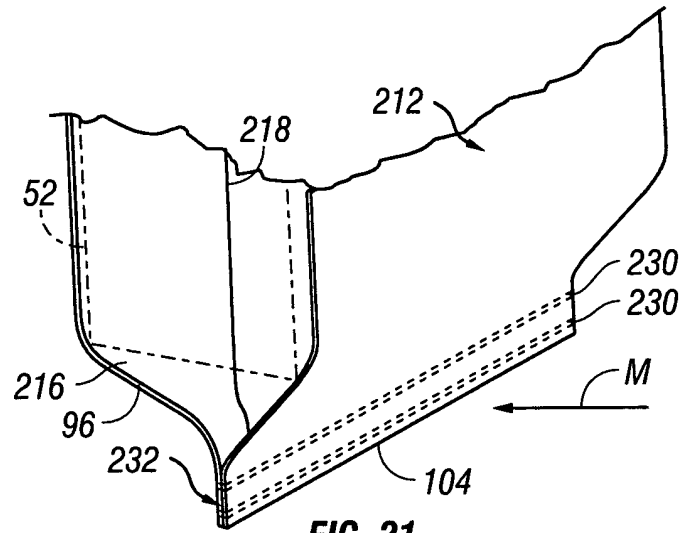


FIG. 21

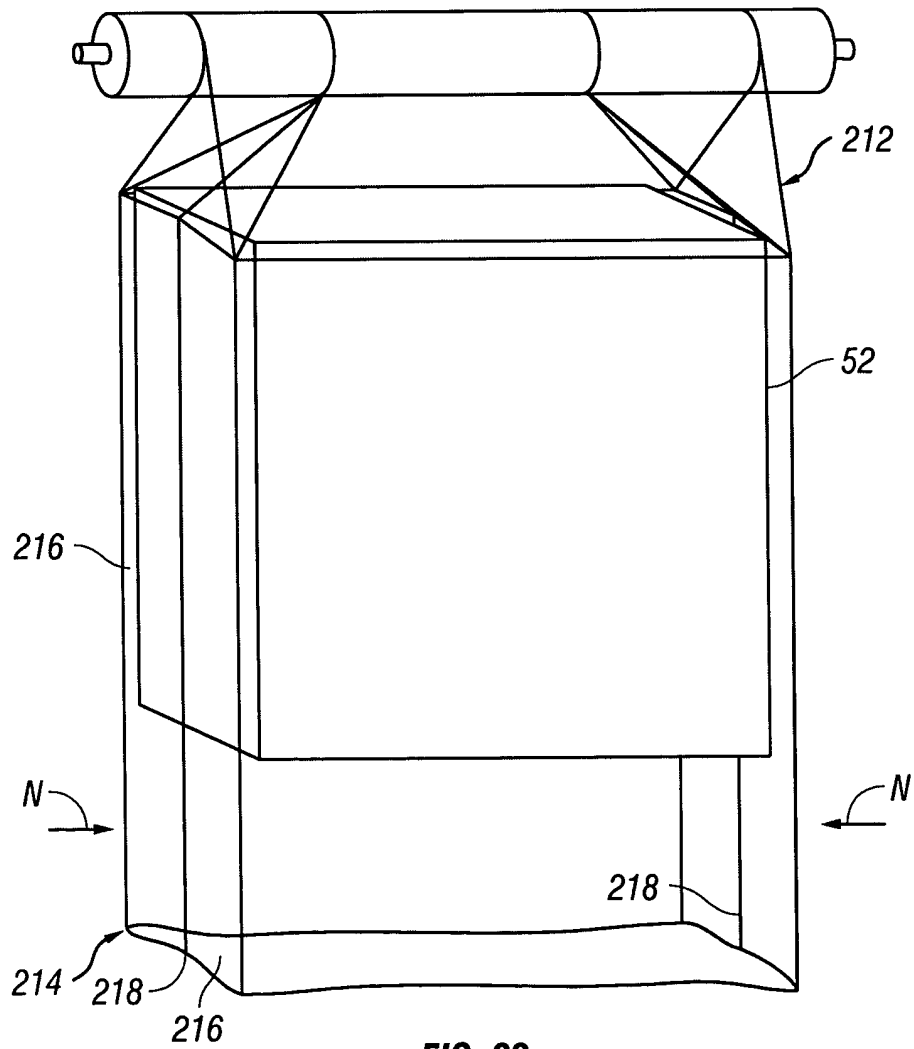


FIG. 22

21/23

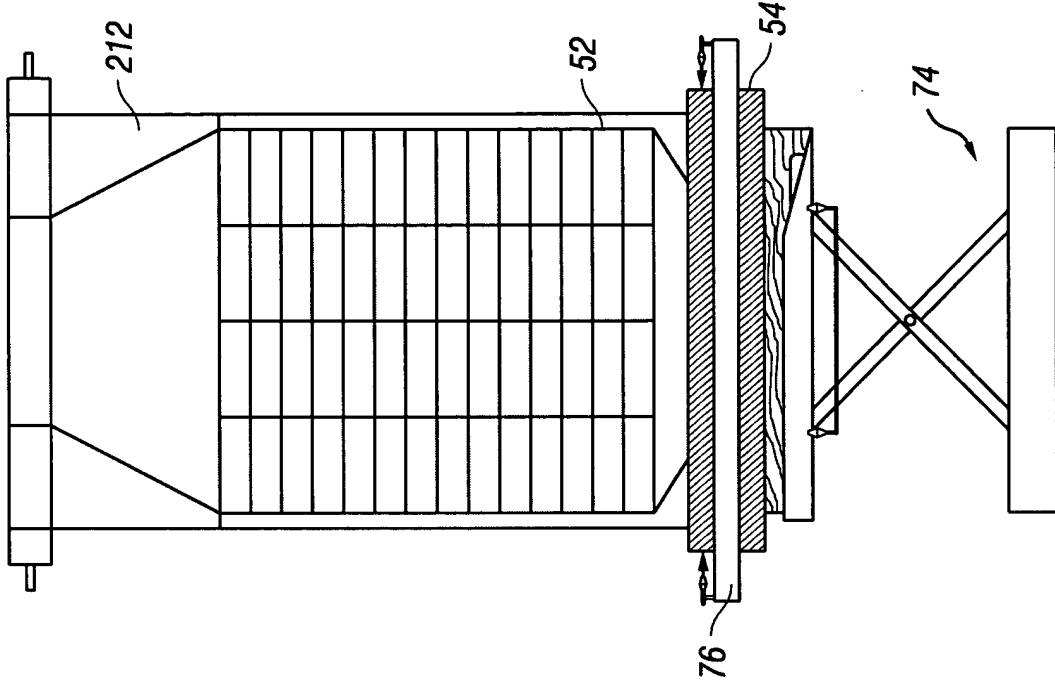


FIG. 24

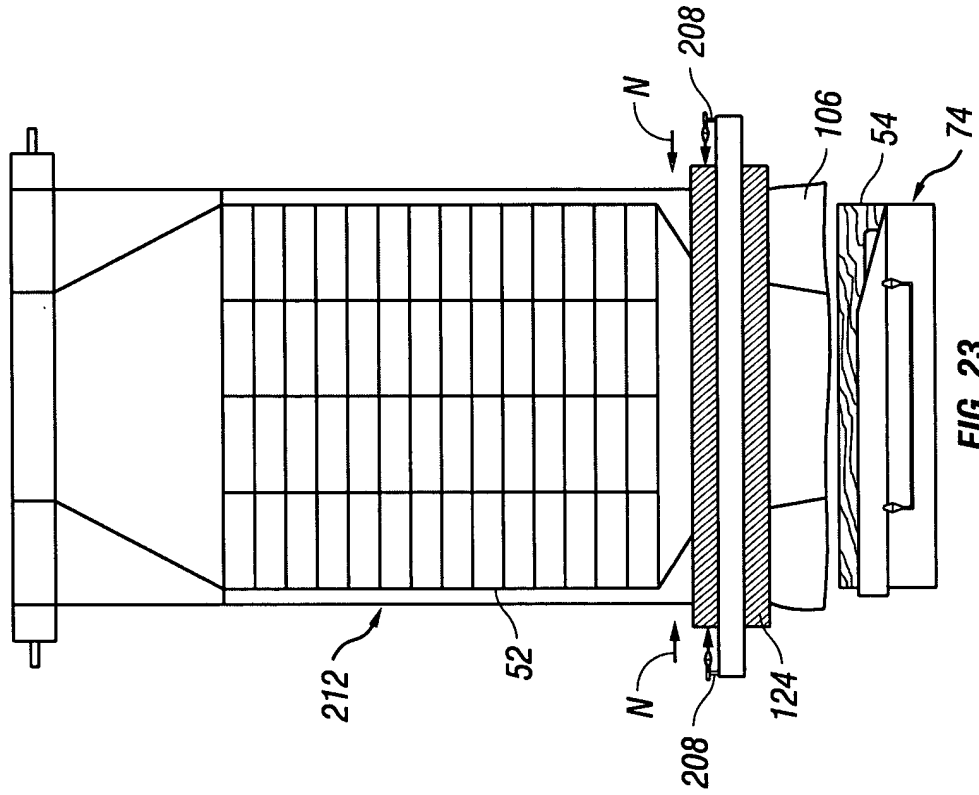


FIG. 23

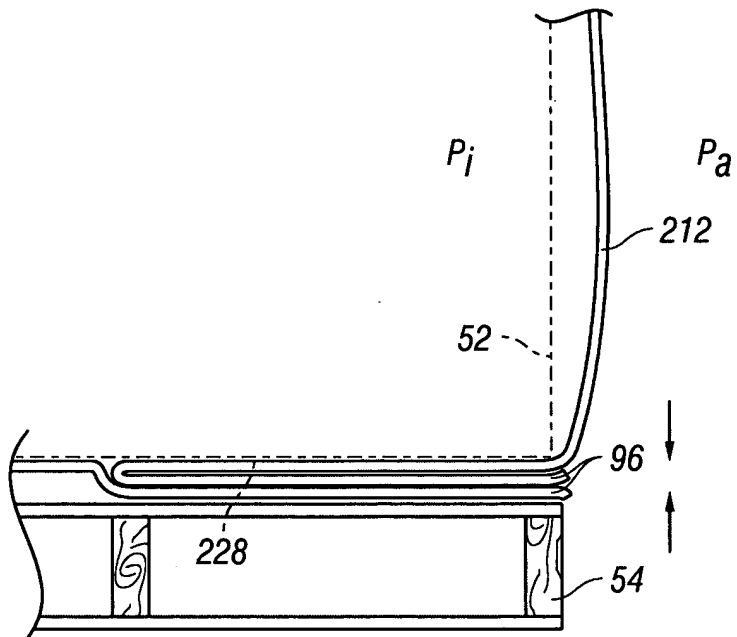


FIG. 25

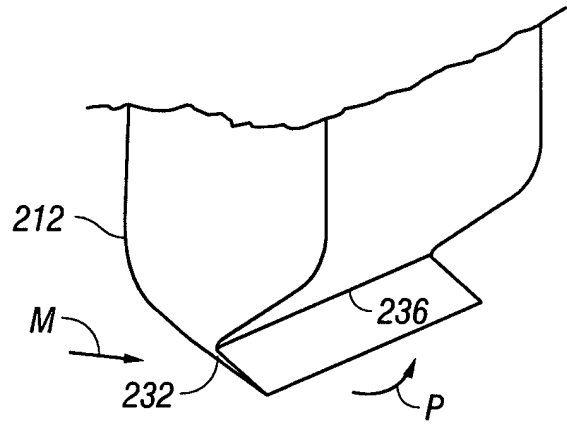


FIG. 26A

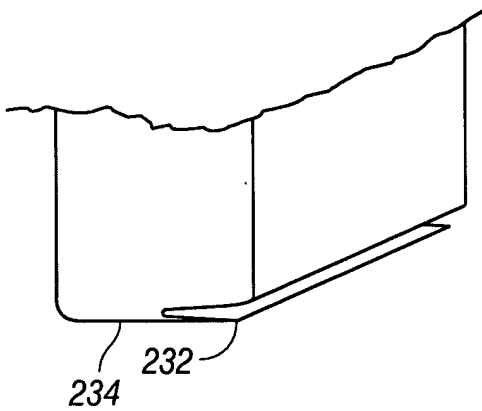


FIG. 26B

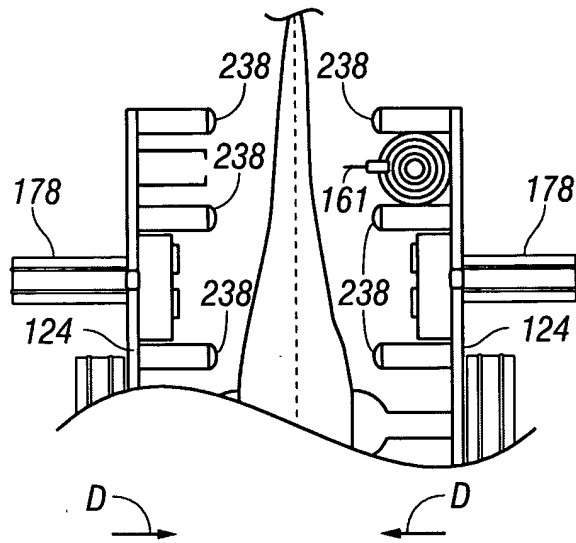


FIG. 27A

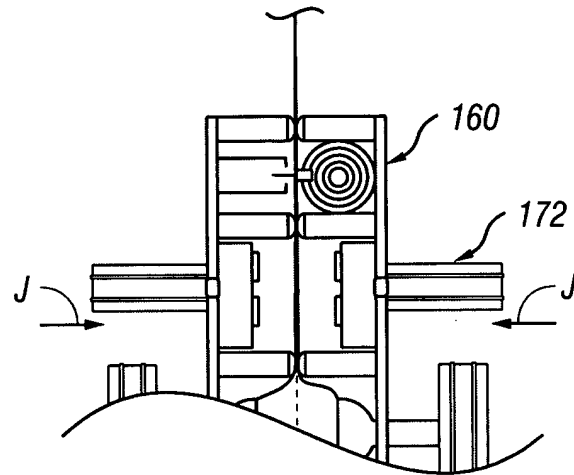


FIG. 27B

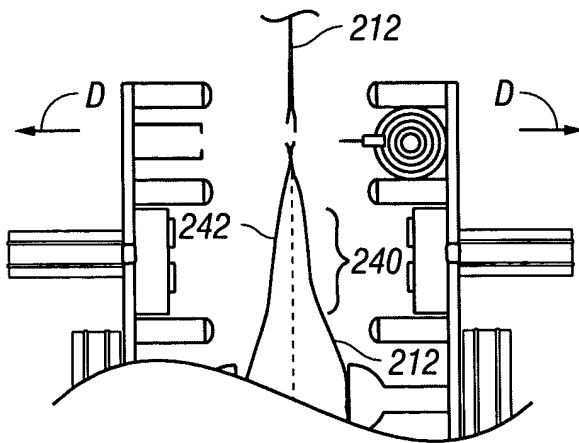


FIG. 27C